

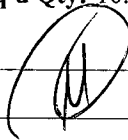
Work Order ID 164442

Wednesday, July 19, 2017 2:34:00 AM

164442

Page 1

Item ID: D4072-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Airframe Hinge
 Start Date: 7/20/2017 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 7/27/2017 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan:  Date: JUL 20 2017 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4072	B

100	Cut blanks as per folio	0.00							
-----	-------------------------	------	--	--	--	--	--	--	--

100
 Bandsaw Memo 0.27 10 SL 17/08/01
 Jeaspa Bandsaw CUT 1.250" LONG

105		0.62							
-----	--	------	--	--	--	--	--	--	--

105
 HAAS 1 Memo 1.75 10 SL 17/08/01
 HAAS CNC vertical machine #1

Memo
 Mill as per Dwg an Folio FA938
 Dwg Rev: B
 Folio Rev: AA

DAS
 39
 9-89

Deburr

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
									QC / QA Coordinator Approval																
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐																		

Work Order ID 164442

Wednesday, July 19, 2017 2:34:00 AM

164442

Page 2

Item ID: D4072-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Airframe Hinge
Start Date: 7/20/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 7/27/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.10				<u>10</u>			5.4 17/08/01 DAS 39 9-89
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.20				<u>10</u>			DAS 49 9-89 17/08/01
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.19				<u>(X10)</u>	<u>0</u>		2017/08/02 BEB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
DART 26 0.01				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 164442

Wednesday, July 19, 2017 2:34:00 AM

164442

Page 3

Item ID: D4072-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Airframe Hinge
 Start Date: 7/20/2017 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 7/27/2017 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per OSI005 4.3-Steel <i>M 13804.</i> Memo	0.00 0.32				<i>10</i>	<i>0</i>	<i>1708-3</i>	<i>DAS 34 9-89</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.10				<i>10</i>			<i>DAS 38 9-89</i> <i>AUG 04 2017</i>
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <i>81072</i> Memo	0.00 0.10				<i>10x</i>			<i>DAS 26 9-89</i> <i>AUG 08 2017</i>

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																																											
Date : _____		Step #: _____			QTY Effective : _____				MRB (QSI042) Approval																																																																																																																																																						
Description Work Order Deviation					Disposition					Completed By																																																																																																																																																					
										Lead hand / Supervisor Approval Verification																																																																																																																																																					
										QC / QA Coordinator Approval																																																																																																																																																					
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> <th colspan="8" style="text-align: left;">FAULT CATEGORY</th> </tr> </thead> <tbody> <tr> <td>Environment</td><td>☐</td><td>☐</td><td>No Re-verification</td> <td>☐</td><td>Pressure/Forced</td> <td>☐</td><td>Temperature/Cure</td> <td>☐</td><td>Power Loss/Surge</td> <td>☐</td><td>Positioned Wrong</td> </tr> <tr> <td>Design</td><td>☐</td><td>☐</td><td>Operator</td> <td>☐</td><td>Bending</td> <td>☐</td><td>Set-up</td> <td>☐</td><td>Folio/Program</td> <td>☐</td><td>Outside Dimensions</td> </tr> <tr> <td>Doc/Data</td><td>☐</td><td>☐</td><td>Offset/Setup</td> <td>☐</td><td>Centre Not Concentric</td> <td>☐</td><td>BOM/Route</td> <td>☐</td><td>Grain</td> <td>☐</td><td>Over/Under tolerance</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td><td>☐</td><td>Supplier</td> <td>☐</td><td>Cracks</td> <td>☐</td><td>Broken/Damage/Defect</td> <td>☐</td><td>Weld</td> <td>☐</td><td>Part Incorrect</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td><td>☐</td><td>Training</td> <td>☐</td><td>Crimp/Kink/Ripple/Wave</td> <td>☐</td><td>Inspection Incomplete/Unqualified</td> <td>☐</td><td>Wrong Stock Pulled</td> <td>☐</td><td>Part Lost/Missing</td> </tr> <tr> <td>Material</td><td>☐</td><td>☐</td><td>Use for Testing</td> <td>☐</td><td>Cuffs</td> <td>☐</td><td>Contamination</td> <td>☐</td><td>Out of Sequence</td> <td>☐</td><td>Part Moved</td> </tr> <tr> <td>Internal Transport</td><td>☐</td><td>☐</td><td>Poor Information</td> <td>☐</td><td>Crushing</td> <td>☐</td><td>Countersink</td> <td>☐</td><td>Off-set</td> <td>☐</td><td>Drawing</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td><td>☐</td><td>Rushing</td> <td>☐</td><td>Heat Treat</td> <td>☐</td><td>Cut Too Short</td> <td>☐</td><td>Mislabeled</td> <td>☐</td><td>Finish</td> </tr> <tr> <td>LOA</td><td>☐</td><td>☐</td><td>Product Improvement</td> <td>☐</td><td>Wave/Twist in Tube</td> <td>☐</td><td>Instructions Incomplete/Unclear</td> <td>☐</td><td>Fit/Function</td> <td>☐</td><td>Misread</td> </tr> <tr> <td>Substation</td><td>☐</td><td>☐</td><td>Process Improvement</td> <td>☐</td><td>Marks/Chatter</td> <td>☐</td><td>Drill Holes</td> <td>☐</td><td>Misaligned/off center</td> <td>☐</td><td>Turning Sequence</td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td><td>☐</td><td>Manufacturing Process</td> <td colspan="8" rowspan="2" style="text-align: center; vertical-align: top;">OTHER : _____</td> </tr> <tr> <td>Misidentified</td><td>☐</td><td>☐</td><td>Past Due</td> </tr> </tbody> </table>												Root Cause				FAULT CATEGORY								Environment	☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	Design	☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	Doc/Data	☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	Equip/Tooling	☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	Handling/Pre	☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	Material	☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	Internal Transport	☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	Tribal Knowledge	☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	LOA	☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	Substation	☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	Past Expiry Date	☐	☐	Manufacturing Process	OTHER : _____								Misidentified	☐	☐	Past Due
Root Cause				FAULT CATEGORY																																																																																																																																																											
Environment	☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong																																																																																																																																																				
Design	☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions																																																																																																																																																				
Doc/Data	☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance																																																																																																																																																				
Equip/Tooling	☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect																																																																																																																																																				
Handling/Pre	☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing																																																																																																																																																				
Material	☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved																																																																																																																																																				
Internal Transport	☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing																																																																																																																																																				
Tribal Knowledge	☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish																																																																																																																																																				
LOA	☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread																																																																																																																																																				
Substation	☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence																																																																																																																																																				
Past Expiry Date	☐	☐	Manufacturing Process	OTHER : _____																																																																																																																																																											
Misidentified	☐	☐	Past Due																																																																																																																																																												

Work Order ID 164442

Wednesday, July 19, 2017 2:34:00 AM

164442

Page 4

Item ID: D4072-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Airframe Hinge
Start Date: 7/20/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 7/27/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	1.00							
Quality Control									

AUG 08 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : ☐																	

Picklist Print

Wednesday, July 19, 2017 2:34:02 AM

Page 1

Work Order ID: 164442

164442

Parent Item: D4072-1

D4072-1

Parent Item Name: Airframe Hinge

Start Date: 7/20/2017

Required Date: 7/27/2017

Start Qty: 10.00

Required Qty: 10.00

Comments:

Ipp Rev:A New Issue 10-06-09 JLM Verified By:DD
REV:B DRAWING REV. CHANGE AS PER ECN 11-598
VERIFIED BY:

IPP
11-07-05 JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.50 0		Purchased	No			100	f	15.3130	0.104	1.094737			

M6061T6B1 000X02 500

**

6061-T6 Bar 1.00 x 2.50

Location

MAT003

Loc Qty

15.313

Loc Code

M128437

0.4

M137365

14.913

0.4
1832

S.C.
17/08/01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

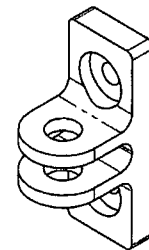
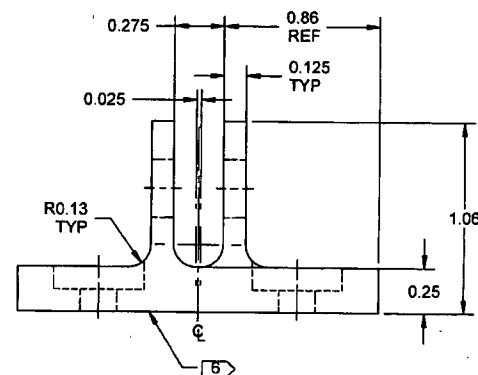
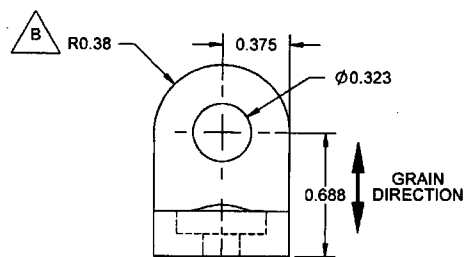
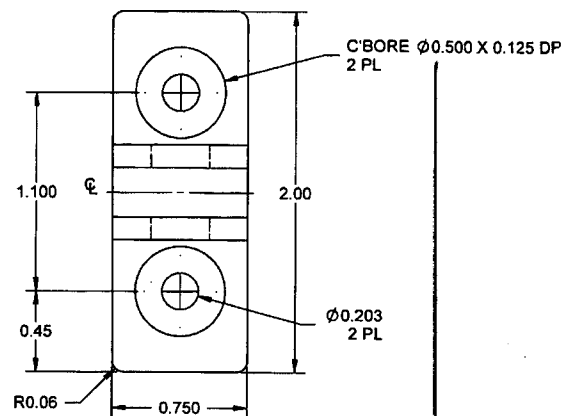
DART AEROSPACE LTD		Work Order: 164442
Description: Airframe Hinge		Part Number: D4072-1
Inspection Dwg: D4072 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500 x 0.125	+/-0.010	Ø0.500	✓		Gauge pin + Ver ED-6	
2.00	+/-0.030	2.000	✓		Ver ED-6	
Ø0.203	+0.005/-0.001	Ø0.203	✓		Gauge pin	
0.750	+/-0.010	0.751	✓		Ver ED-6	
R0.06	+/-0.030	R.06	✓		R.G.	
0.45	+/-0.030	0.449	✓		Ver ED-6	
1.100	+/-0.010	1.100	✓		"	
R0.38	+/-0.030	R.380	✓		R.G.	
0.375	+/-0.010	0.374	✓		Ver ED-6	
0.688	+/-0.010	0.687	✓		Ver ED-6	
0.275	+/-0.010	0.275	✓		Ver ED-6	
R0.13	+/-0.030	R.130	✓		R.G.	
0.25	+/-0.030	0.245	✓		Ver ED-6	
1.06	+/-0.030	1.06	✓		Ver ED-6	
0.125	+/-0.010	0.125	✓		Ver ED-6	
0.86	+/-0.030	0.862	✓		H.G.	
Ø0.323	+0.005/-0.001	Ø0.323	✓		G.P.	

Measured by: SC. Date: 17/08/01	Audited by: DAS 49 Date: 9-89 17/08/01	Preliminary Approval: Date:
--	---	--

Rev	Date	Change	Revised by	Approved
A	11.06.26	New Issue	KJ	
B	11.10.13	Dimension 0.25 removed	KJ	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164442
JUL 20 2017

D4072-1 AIRFRAME HINGE

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMD 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

RELEASED
2011-06-30

B	CORRECT TYPO (ZN B7-1)	RF	10.11.02
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.02		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO.		REV. B	
D4072		SHEET 1 OF 3	
TITLE		SCALE	
AIRFRAME HINGE		NTS	
COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			